

Date: Monday, 6/5/2006 7:48:03 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOUBLER	
Job Number	: 27380		Part Number	: D3144111	
Estimate Number	: 10633		Drawing Number	: D3144 REV C	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 6/5/2006 S.O. No. : N/A		Drawing Revision	: C	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 6/30/2006	
Previous Run	: N/A		Qty:	4 Um: Each	
Written By	: See comment below				
Checked & Approved By	: KJ 06.06.05				
Comment	: Est. A 04.11.29 New issue KJ/RF				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
		 <del>Comment: PURCHASING</del> <del>Issue P/O:</del> <del>Email or Ship DXF file to vendor</del> <del>Laser Cut D3144-111 flat pattern per Dwg D3144</del> <del>Possible Supplier: GFI or Industrial Laser</del> <del>Material release note is required</del> <del>M 2024 T3 S032 0.032" thick</del> <del>batch: M100284</del> <del>(0.160 sqft) M 06 07</del>
2.0	←D3144115F→ Water Jet	<del>Doubler</del>  <del>Prog. rev. C</del> <del>Dwg rev. C</del> <del>M 06 07 4</del>
3.0	PACKAGING1 QC2	<del>PACKAGING RESOURCE #1</del>  <del>QC1 06 06 07 (4)</del>
4.0	QC8 QC8	<del>DIMENSIONAL CHECK</del>  <del>QC8 06 08 4</del>
5.0	SMALL FAB 1	<del>SMALL &amp; MEDIUM FAB RESOURCE 1</del>  <del>SMALL FAB 1 06:06:11 (4)</del>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

NCR: Yes

DQA: 

Date: 06/06/27

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

Date: Monday, 6/5/2006 7:48:04 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 27380

Part Number: D3144111

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
7.0	POWDER COATING	POWDER COATING 
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
9.0	PACKAGING 1	PACKAGING RESOURCE #1 
10.0	DC	DOCUMENT CONTROL 

Job Completion



U 06/06/26 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

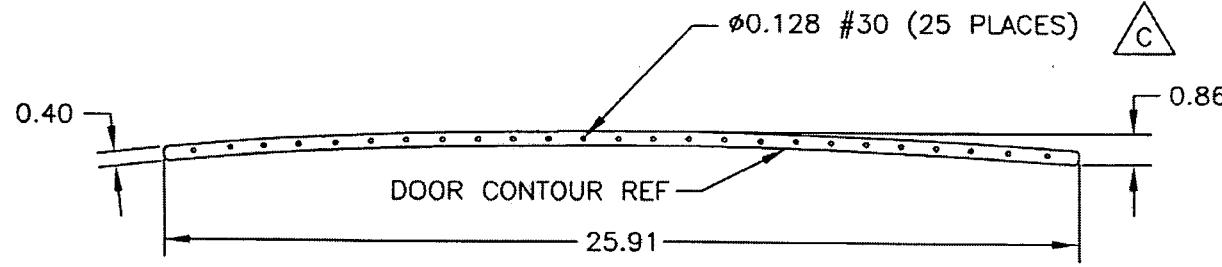
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

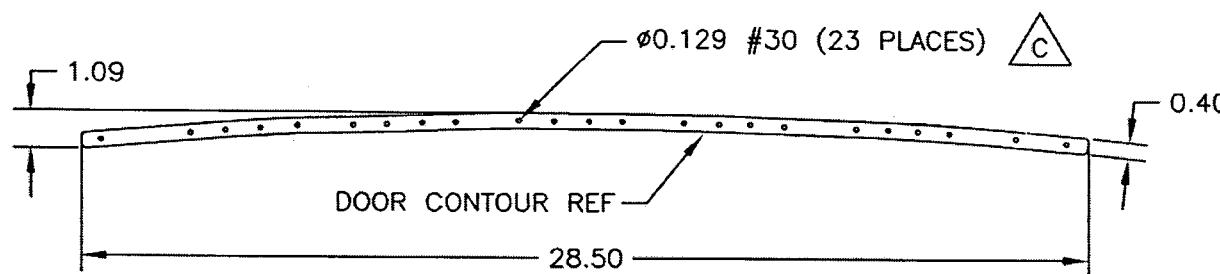
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05.11.14

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CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	HAWKESBURY, ONTARIO, CANADA
DATE 05.10.19	TITLE DOUBLER	REV. C
A 05.10.19	02.04.22	NEW ISSUE
B 04.09.17		ADDED D3144-105/-107/-109/-111/-115/-121/-123; MODIFY D3144-1
C 05.10.19		ADD D3144-15; $\phi$ 0.129 WAS $\phi$ 0.098



**D3144-1 DOUBLER (FOR D412-694-03)**  
REPLACES PREMIER P/N B30-23000-191



**D3144-3 DOUBLER (FOR D412-694-01)**  
REPLACES PREMIER P/N B30-23000-193

**D3144-1/-3 NOTES:**

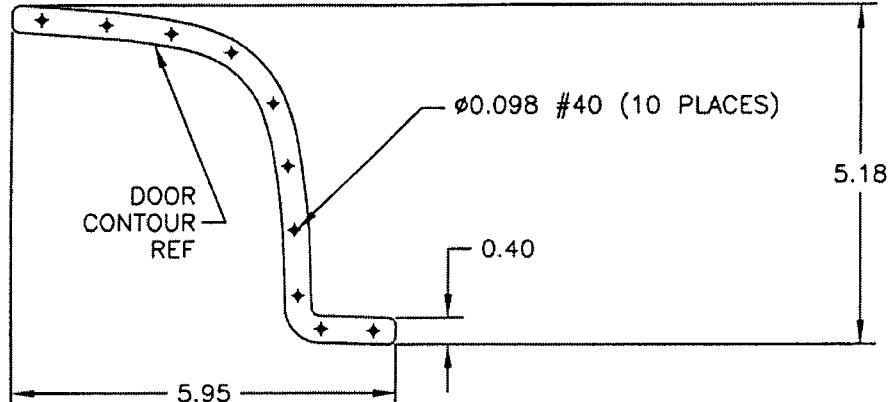
- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING "D3144-C1.DWG"

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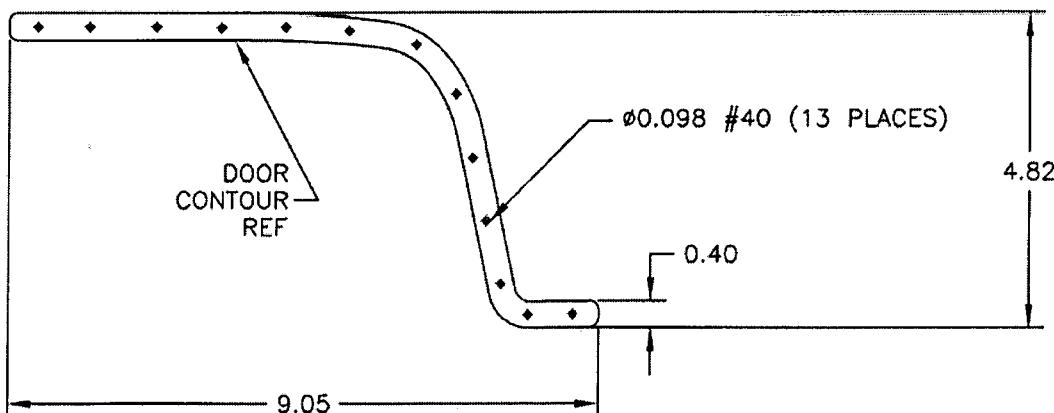
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DATE 05.10.19	TITLE DOUBLER	REV. C SHEET 2 OF 9 SCALE NTS



**D3144-5 DOUBLER**  
REPLACES PREMIER P/N B30-23000-195



**D3144-7 DOUBLER**  
REPLACES PREMIER P/N B30-23000-197

**D3144-5/-7 NOTES:**

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING "D3144-C2.DWG"

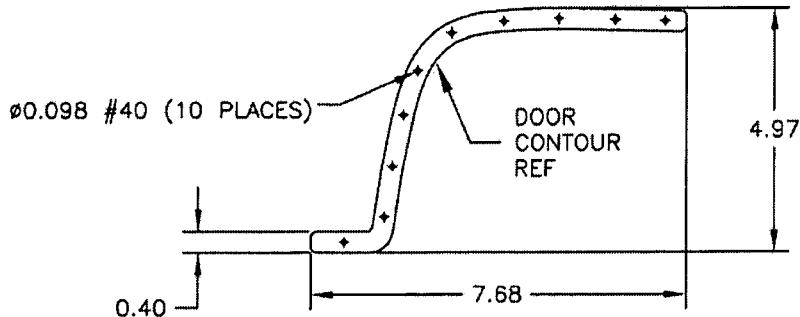
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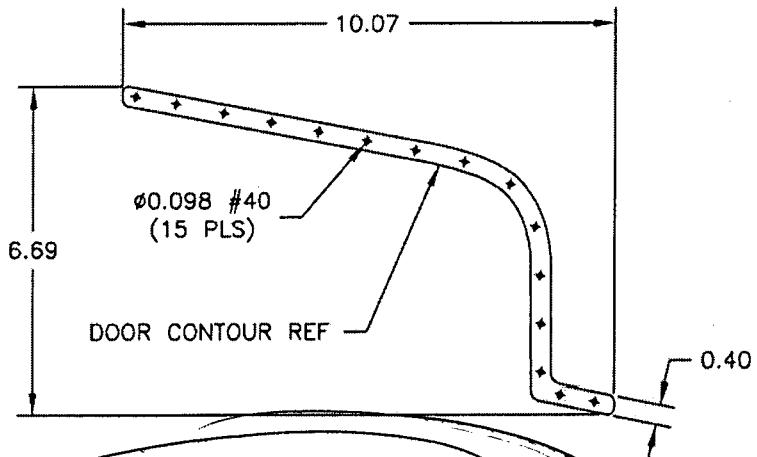
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DATE 05.10.19	TITLE DOUBLER	REV. C SHEET 3 OF 9 SCALE NTS



**D3144-9 DOUBLER**  
REPLACES PREMIER P/N B30-23000-199



**D3144-11 DOUBLER**  
REPLACES PREMIER P/N B30-23000-203

**D3144-9/-11 NOTES:**

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING FILE "D3144-C3.DWG"

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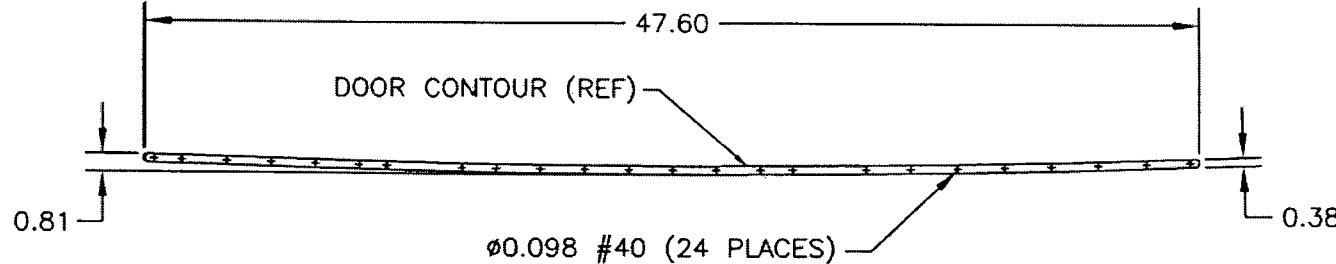
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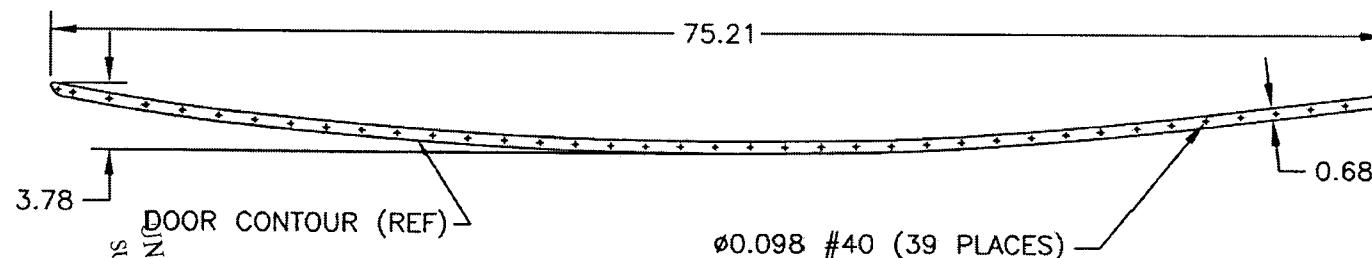
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**D3144-15 NOTES:**

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING FILE "D3144-C4.DWG"



**D3144-13 DOUBLER**

SCALE 1:10

REPLACES PREMIER P/N B30-23000-211

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JN CONTROL 13 NOTES:  
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NO. 273  
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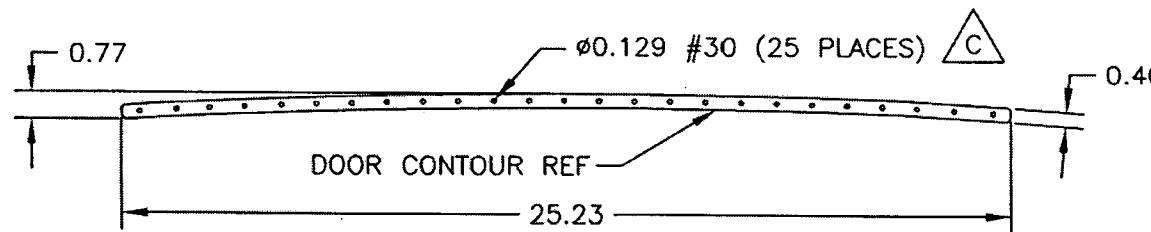
- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.020 THICK (REF DART SPEC M2024T3S.020)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING FILE "D3144-C4.DWG"

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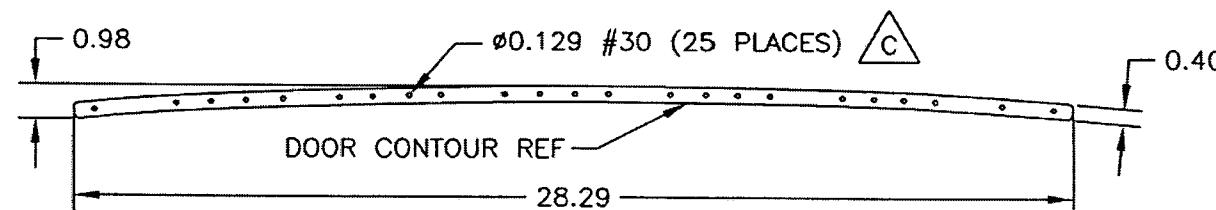
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DATE		TITLE		SHEET 4 OF 9	
05.10.19		DOUBLER		SCALE	
				NTS	

NO. 27380



D3144-119 DOUBLER (FOR D412-694-04)



D3144-123 DOUBLER (D412-694-02)

**D3144-119/123 NOTES:**

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING FILE "D3144-C5.DWG"

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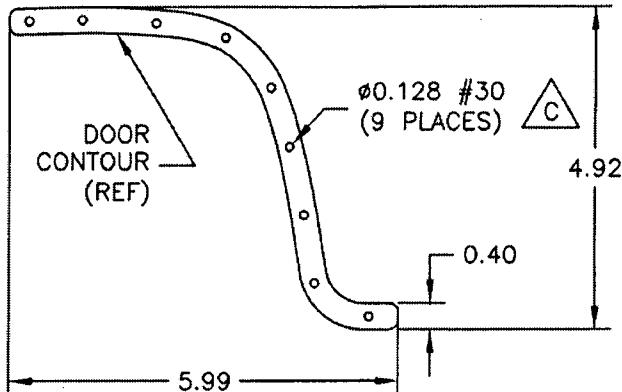
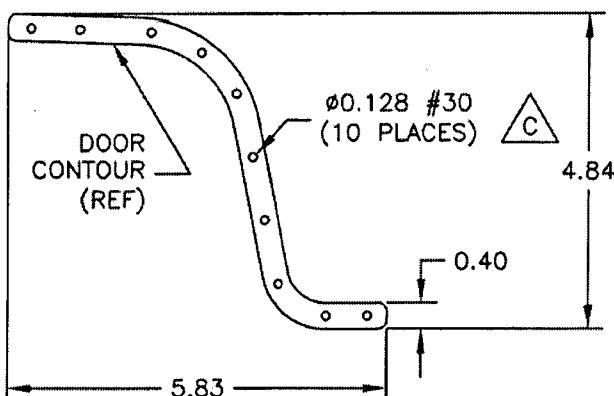
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DATE 05.10.19	TITLE DOUBLER	REV. C SHEET 5 OF 9 SCALE NTS

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DATE 05.10.19		TITLE DOUBLER	SCALE NTS

**D3144-105 DOUBLER (FOR D412-694-03)****RELEASED**

05-11-14

**D3144-117 DOUBLER (FOR D412-694-04)****D3144-105/-117 NOTES:**

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING "D3144-C6.DWG"

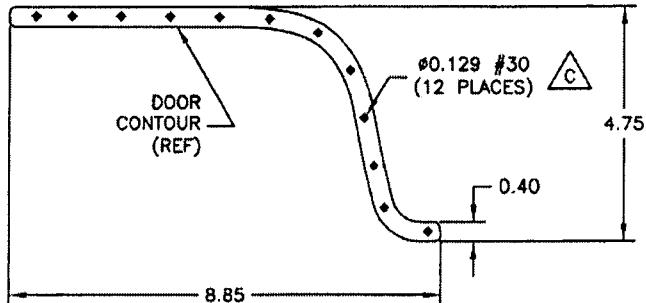
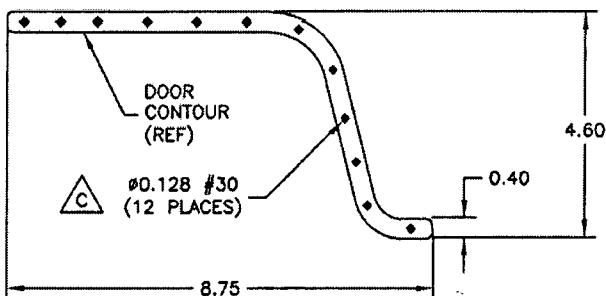
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DATE 05.10.19		TITLE DOUBLER	SCALE NTS

**D3144-107 DOUBLER (FOR D412-694-03)****D3144-121 DOUBLER (FOR D412-694-04)****RELEASED**

05-11-14

**D3144-107/-121 NOTES:**

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING FILE "D3144-C7.DWG"

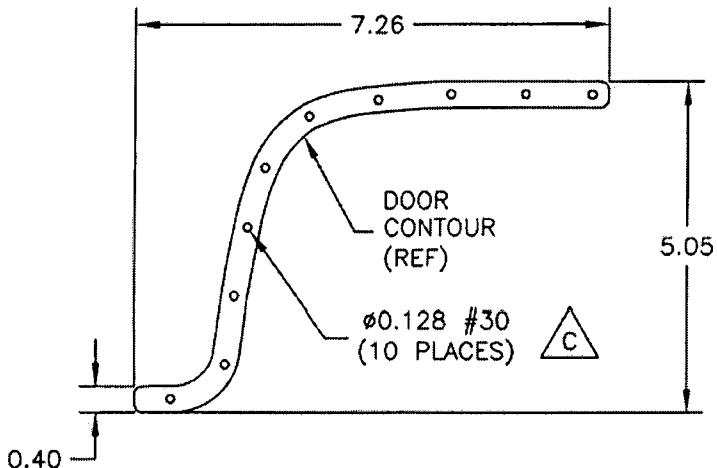
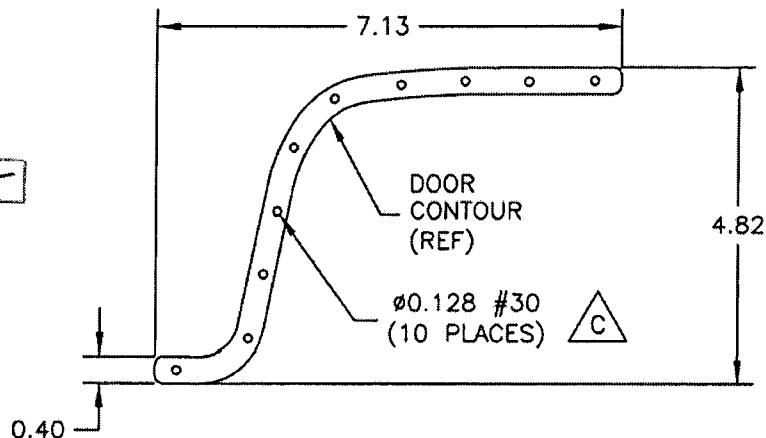
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DATE 05.10.19		REV. C SHEET 8 OF 9 TITLE DOUBLER SCALE NTS

D3144-109 DOUBLER (FOR D412-694-01)D3144-115 DOUBLER (FOR D412-694-02)**D3144-109/-115 NOTES:**

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S1032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
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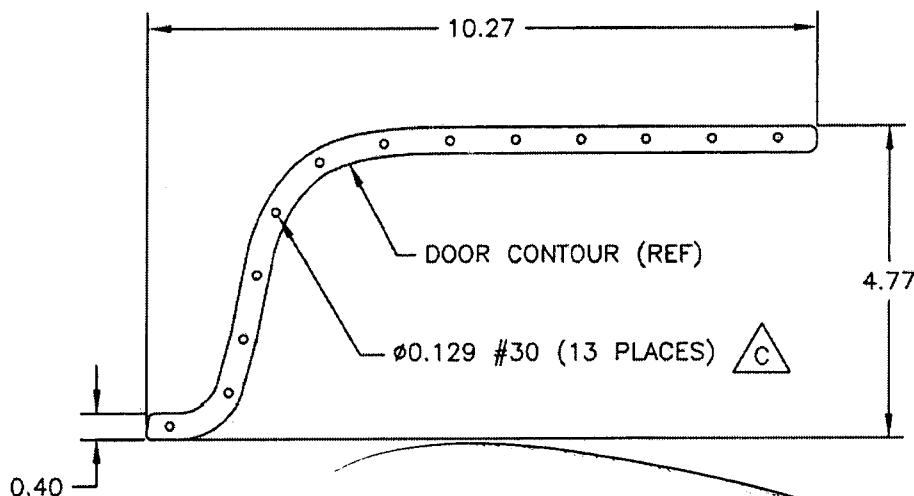
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DATE 05.10.19		TITLE DOUBLER	SCALE NTS

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05.11.14

D3144-111 DOUBLER (FOR D412-694-01/-02)**D3144-111 NOTES:**

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING "D3144-C9.DWG"

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**DART AEROSPACE LTD**

Work Order: 27380

Description: SP00BLEZ

Part Number: 3144111

Inspection Dwg: D3144 Rev: C

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Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article X Prototype

Measured by

**Audited by:**

### Prototype Approval:

F-200

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P

— 8 —

1

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

4